

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015299**Date Inspected:** 29-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Wei an**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Art Peterson was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) on Segment 11AE

This QA Inspector performed UT 10% verification inspection on areas previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date. The welds inspected were identified as follows:

SEG 066C {001, 002, 013, 014}

SEG 066B {005, 006, 025, 026}

SSD19 PP97 {108, 132, 135, 136}

SSD19A PP97 {108,128, 131, 134}

During the QA Inspectors' UT verification inspection of welds located inside of Orthotropic Box Girder (OBG) Segment 11AE, this QA Inspector while scanning on weld joint SEG 066C-002 longitudinal diaphragm LD 2A flange to Floor beam FB10A web plate on west side of Panel Point PP 097, discovered the following issue of one (1) longitudinal linear indication measuring approximately 30mm in length. The indication decibel rating was a (+3). The material thickness was 25mm. The depth of the indication was approximately 24mm. The weld is a complete joint penetration (CJP) "T" joint single bevel groove weld. The weld is designated as Non Seismic Performance Critical Material (Non SPCM). The indication was clearly marked on or near the weld. The "Y"

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## WELDING INSPECTION REPORT

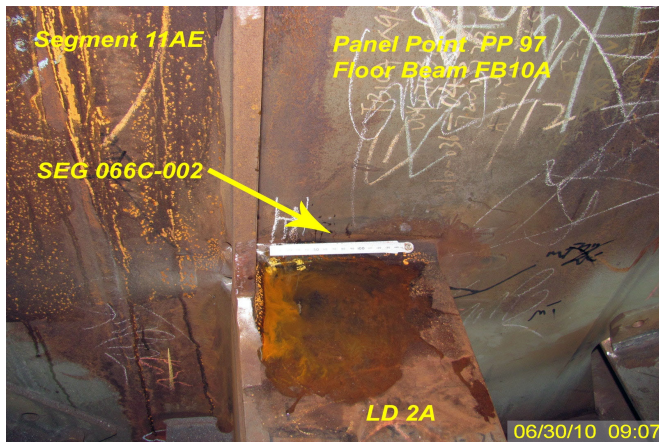
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distance for this indication was 10 mm. The Notice of Witness Inspection (NWIT) No. was 006079. The indication was located within the area previously tested and accepted by ZPMC QC personnel. As per the contract documents, ZPMC's QC personnel are required to perform one hundred (100%) percent UT inspection of this weld. See attached Photo.

The QA inspector generated an incident report on this date for review and disposition for the above UT indication issue.

Unless otherwise noted above, the UT verification inspection performed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang at 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Peterson, Art	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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